

Date: Monday, 15/06/2009 4:20:02 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : REAR OVERHEAD R/H, IVORY
Job Number : 48591B	
Estimate Number : 13590	
P.O. Number :	Part Number : D38232KIV
This Issue : 15/06/2009 S.O. No. :	Drawing Number : D3823-2
Prsht Rev. : NC	Project Number :
First Issue : // Type : THERMOFORMING	Drawing Revision : <i>BC</i>
Previous Run : 47670B	Material : MKYD6185S080P362015
Written By :	Due Date : 22/06/2009 Qty: <i>3</i> Um: Each
Checked & Approved By : <i>JUD 09-06-15</i>	
Comment : Est. A New Issue 08/09/17 DL Rev B Dwg. Update. 09/02/09 DL verified by:DD Est Rev C Add Colour Code 09/06/02 DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MKYD6185S080P362015	6185 KYDEX .080"
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Comment: Qty.: 11.3747 sf(s)/Unit Total : 56.8733 sf(s)
 6185 Kydex .080" Ivory

M109703 BB 09/06/22

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/06/22 x 1

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/06/22 (X3)

4.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3823-2 and folio FTA 031 using tool DT 9113

Dwg. Rev. *C*

Folio Rev. *B*

BB 09/06/22 (X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 15/06/2009 4:20:02 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR OVERHEAD R/H, IVORY

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Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/06/23 X3
X3

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

DL 09/06/22

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

DL 09/06/23

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

DL 09/06/23

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50/06/23 X3

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

DL 09/06/23

3X

SEP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/23 X3

Job Completion



MR
09-06-23

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 4859/13
Description:	Part Number: 3823-2 K1U
Inspection Dwg: D3823-2 Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: Whe

Date: 08/06/23

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.5"	MIN	0.605"	✓			
0.44"	MIN	0.55"	✓			
0.75"	MIN	1.82"	✓			
0.045"	MIN	0.063"	✓			
0.055"	MIN	0.075"	✓			

Measured by: Whe

Date: 09/06/23

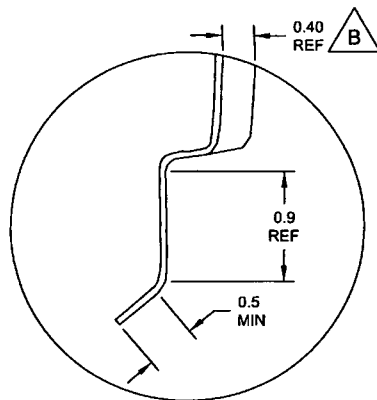
Audited by: B

Date: 09/06/23

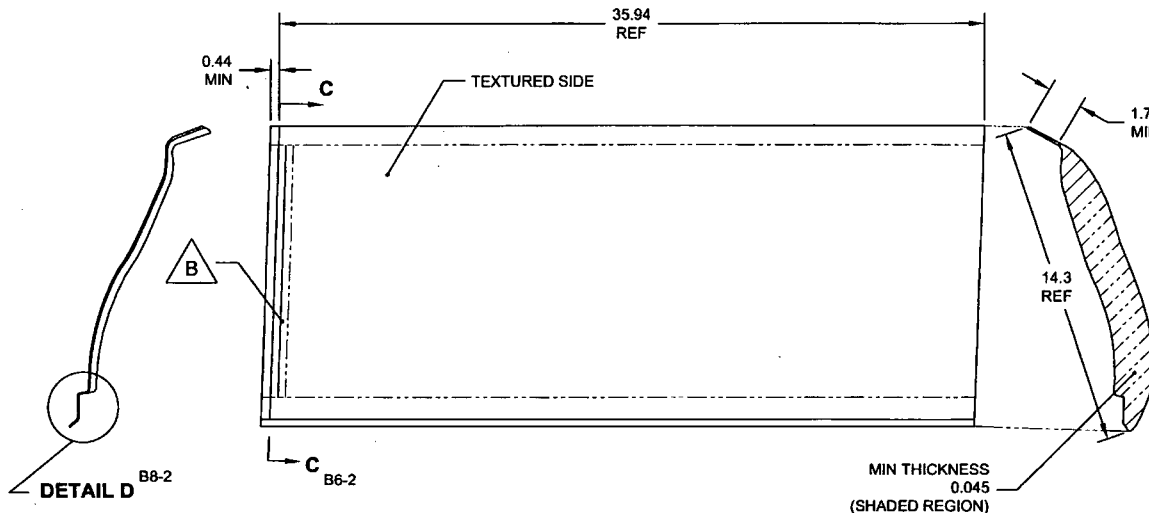
Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



SECTION C-C



D3823-2 REAR OVERHEAD, RH

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.9 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9113 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3823-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3823-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3823 SHEET 2 OF 3
APPROVED		TITLE SCALE
DE APPR.		REAR OVERHEAD NTS
DATE	09.05.05	

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RELEASED
09/12/12

NO WORK SENT
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ENGINEERING
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SCALE 5X
DETAIL D
B5-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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